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D3913-041
Job Sheet 201181



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/26/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV:B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/21/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/21/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18	DAS	
							QC 5 - 19	24	
120	QC 5	1 pcs	10/21/19		0.00	0.00	QC 5 - 22	9-89	
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

MAC



Container No: S231491



Part: D3913 - 041

Job No: 201181

Serial No/Batch: S231491

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/19/19

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/21/19	0.00 0.29	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	BK 19-11-21
					Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)-B4B	1 pcs	10/21/19	0.00 0.93	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-11-21
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	10/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	MA 19-11-22
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/21/19	0.00 0.50	Handfinish - 4 - 1 - B4B	MA 19-11-22
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	

DAS
15
-89

9/26/2019

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					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
160 QC 5	1 pcs	10/21/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	10/21/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

DAS

NOV 27 2019 68

9-89

11-11-28

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					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	10/21/19	0.00	0.00	QC 21 - SA - 21	NOV 22 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: *M139016* 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

M211886 START: 1:55 Q.T. 1:40 FINISH: 2:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	514321
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5109116
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	511077
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	519906
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5200145
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	514555
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	524354
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5216812
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5213354
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	520292
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214645
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	520279
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	521134
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5225815
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5226003
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211019
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5218434
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	520235
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5202554
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5211533
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5216587
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	522076
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5220790
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	513636e

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	135	0
	D3913-1	1	11	0
	D3913-15	1	28	0
	D3913-3	1	7	0
	D3913-7	2	20	0
	D3913-9	1	14	0
	D3916-041	2	12	0
	D3916-5	3	12	0
	D4016-1	3	59	0
	D4017-7	3	37	0
	D4017-9	2	32	0
	D4020-11	2	14	0
	D4021-1	3	76	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	35	0
	M304EX0.75-16F	32	659	0
	AN3-10A	6	170	0
	D2931	2	641	0
150-Handfinish - 4-1-Assembly-B4B	D4021-5	2	10	0
	MS20600-AD4W3	2	366	0
	MS21042L3	6	1,485	0
	NAS1149F0332P	12	3,297	0
	NAS1149FN832P	2	1,797	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

Sequence #: _____

QTY Affected: _____

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Undeclared Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____